

Date: Tuesday, 10/02/2009 3:09:07 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SHOULDER HARNESS KIT
<b>Job Number</b>	: 45712		
<b>Estimate Number</b>	: 13048		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D350764011
<b>This Issue</b>	: 10/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: N/A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 45488	<b>Drawing Revision</b>	: B
	<b>Type</b> : PURCHASED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 23/02/2009
<b>Checked &amp; Approved By</b>	: <u>JUD 09.02.10</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: EST REV:A New issue 07-10-11 DD verified by EC Est Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



*for JUD 09/02/07*



**Comment:** DOCUMENT CONTROL D3638-1 @ Rev.B CHG002 S 07/03/08  
 Photocopy bluefile & type labels per PPP D350-764-011 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

3.0	D2854	3/4" Velcro Strip
-----	-------	-------------------



**Comment:** Qty.: 2.6660 f(s)/Unit Total: 2.6660 f(s)  
 3/4" Velcro  
 Cut qty 4 D2854-1-080 (8" each) as per dwg D2854  
 Batch: 39405 *8/2/26*

4.0	D2854	3/4" Velcro Strip
-----	-------	-------------------



**Comment:** Qty.: 2.6660 f(s)/Unit Total: 2.6660 f(s)  
 3/4" Velcro  
 Cut qty 4 D2854-3-080 (8" each) as per dwg D2854  
 Batch: 39405 *8/2/26*

5.0	D3578041	Doubler
-----	----------	---------



**Comment:** Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
 DOUBLER  
 batch 43347 *8/2/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 45712

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D3636041	Shoulder Harness
-----	----------	------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
SHOULDER HARNESS  
batch 42141

7.0	D3637041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BRACKET ASSEMBLY  
batch 43353

8.0	D36373	Bracket
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BRACKET  
batch 43184

9.0	D36381	Bushing
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BUSHING  
batch B 34659 45876

10.0	D36391	Doubler
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
DOUBLER  
batch 35128

11.0	D36392	Doubler
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
DOUBLER  
batch 42299

12.0	D36393	Doubler
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
DOUBLER  
batch 35382

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 45712

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	D36394	Doubler
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
DOUBLER  
batch 35383

SS 09/02/26 (X)

14.0	D36401	Belt Guide
------	--------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
BELT GUIDE  
batch 43354

SS 09/02/26 (X)

15.0	D36403	Belt Guide
------	--------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
BELT GUIDE  
batch 43356

SS 09/02/26 (X)

16.0	D36411	Cover
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
COVER  
batch 42298

SS 09/02/26 (X)

17.0	D36413	Cover
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
COVER  
batch B43232

SS 09/02/26 (X)

18.0	D36414	Cover
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
COVER  
batch B44671

PC 09/3/18 (1)

19.0	D36421	Doubler
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
DOUBLER  
batch B43234

SS 09/02/26 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 45712

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

20.0	D36431	Stiffener
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
STIFFENER  
batch B34547

21.0	D36432	Stiffener
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
STIFFENER  
batch 34548

22.0	D36441	Shim
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
SHIM  
batch 35392

23.0	D36571	Guide Tool
------	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GUIDE TOOL  
batch B34550

24.0	ALS41032130	Insert
------	-------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Insert  
batch M105819

25.0	AN33A	Bolt
------	-------	------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)  
Bolt  
batch M110002

26.0	AN36A	Bolt
------	-------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Bolt  
batch M109752

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 10/02/2009 3:09:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 45712

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

107178

SS 09/02/2009

28.0

AN960JD10

Washer



Comment: Qty.: 48.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

batch

M110139

SS 09/02/2009

29.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M110523

SS 09/02/2009

30.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M110002

SS 09/02/2009

31.0

AN9706

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M1109798

SS 09/02/2009

32.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Cherry Rivet

batch

M110625

SS 09/02/2009

33.0

CR321242

Cherry Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cherry Rivet

batch

M1107394

SS 09/02/2009

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 45712

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0

CR3212504

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M100321

35.0

CR3212507

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M105978

36.0

MS20426AD33

Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

batch

M1563.

37.0

MS20426AD44

Rivet



Comment: Qty.: 106.0000 Each(s)/Unit Total : 106.0000 Each(s)

Rivet

batch

M15541

38.0

MS20426AD46

Rivet



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Rivet

batch

M65144

39.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet, Universal Head

batch

M109371

40.0

MS21059L3

Nut Plate



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

batch

M67394

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 45712

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

41.0	MS21072L3	Nutplate
------	-----------	----------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Nutplate  
batch M16002

*JS 9/18/2009*

42.0	MS35206267	Screw
------	------------	-------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Screw  
batch M109389

*JS 9/18/2009*

43.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

*S 07/03/18*

44.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D350-764-011  
Location: B  
PPP Rev: B

*PC 9/3/18*

45.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/18*

Job Completion



*h 09.03.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries